

Work Order ID 55066

January 5, 2010 2:39:36 PM



✱

Page 1

Item ID: D3201-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req Qty: 12.00



Custom:

Reference:

Approvals:

Process Plan:

PL

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3201	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201

Dwg Rev: B

Prog Rev: B

□2-

Deburr if necessary

10-1-13

2071 650

18

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-1-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 5/10/11/19

418

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

SAD
10-01-09

18

Small Fab

Debur Stack

140



Brake NC

NC BRAKE

Memo

0.00

0.00

Srs 10/01/24

18

8

Brake NC

1-Bend as per Dwg D3201
dwg D3201

2-Scribe part# and Batch# per

150



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8106127

48
-4's

Quality Control

W/O:		WORK ORDER CHANGES					
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Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> Jell 10-01-27 (18) 0

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

= 7m-1 10/01/27 (18x)

Quality Control

180

Identify as per dwg & Stock Location: 44

0.00



Packaging

Memo

0.00

10-1-27 18x SP

Packaging

W/O:		WORK ORDER CHANGES					
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Page 4

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27

MF

10-1-27

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:39:40 PM

Page 1

Work Order ID: 55066



Parent Item: D3201-4



Parent Item Name: Doubler


Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Exte Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	172.3533	0.5684	1		
												
2024-T3 .050 sheet												
18 10-1-13												



18 10-1-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

172.3532842

111381

36.3165842

112291

88.0367

113189

48

18

112291

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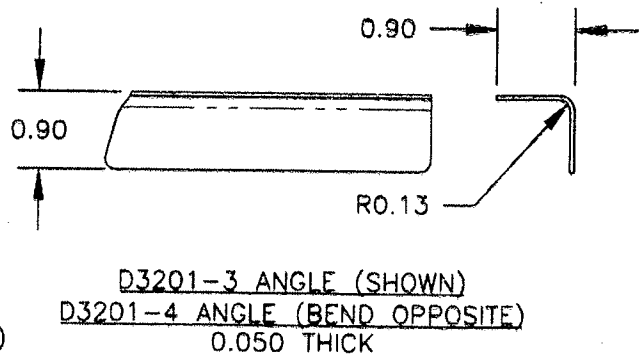
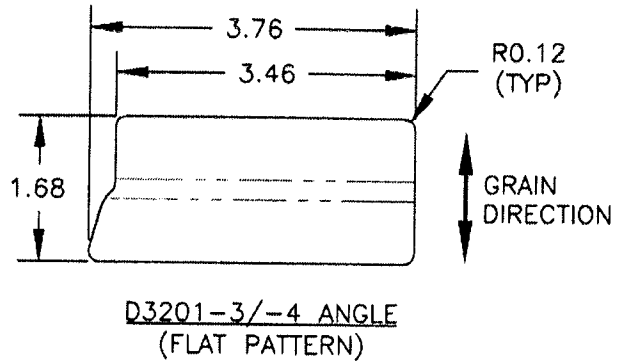
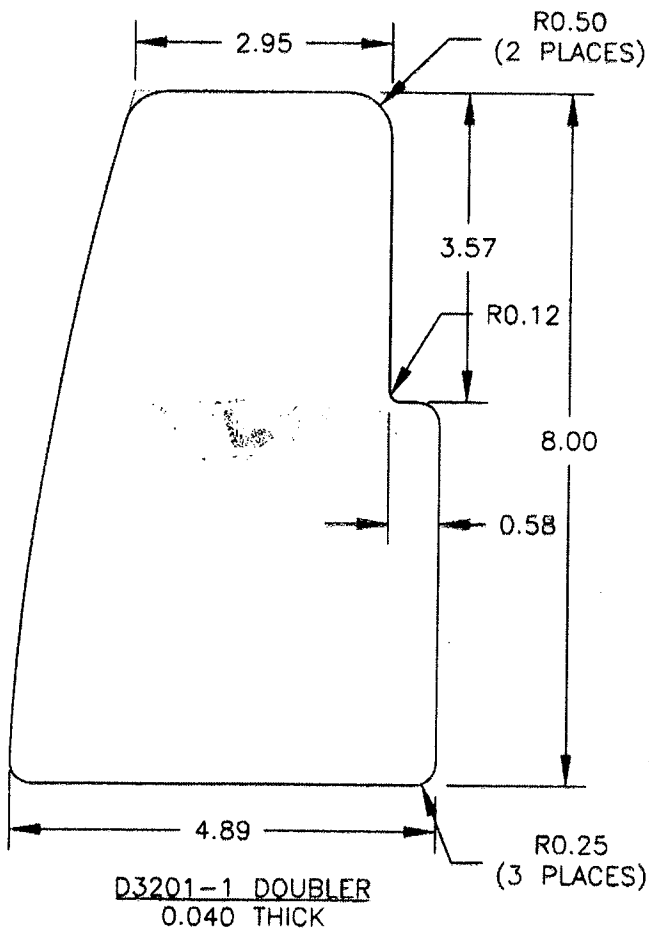
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DESIGN		DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3201 REV. B SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE		
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4		

RELEASED
03.11.14



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55066

10-1-05

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